

ABSTRACT OF THE DISCLOSURE

In accordance with the present invention, a casting system is provided which broadly comprises a core and a wax die spaced from said core, a refractory metal core having a first end seated within a slot in the core and a second end contacting the wax die for positioning the core relative to the wax die, and the refractory metal core having at least one of a mechanism for providing spring loading when closed in the wax die and a mechanism for mechanically locking the wax die to the core.